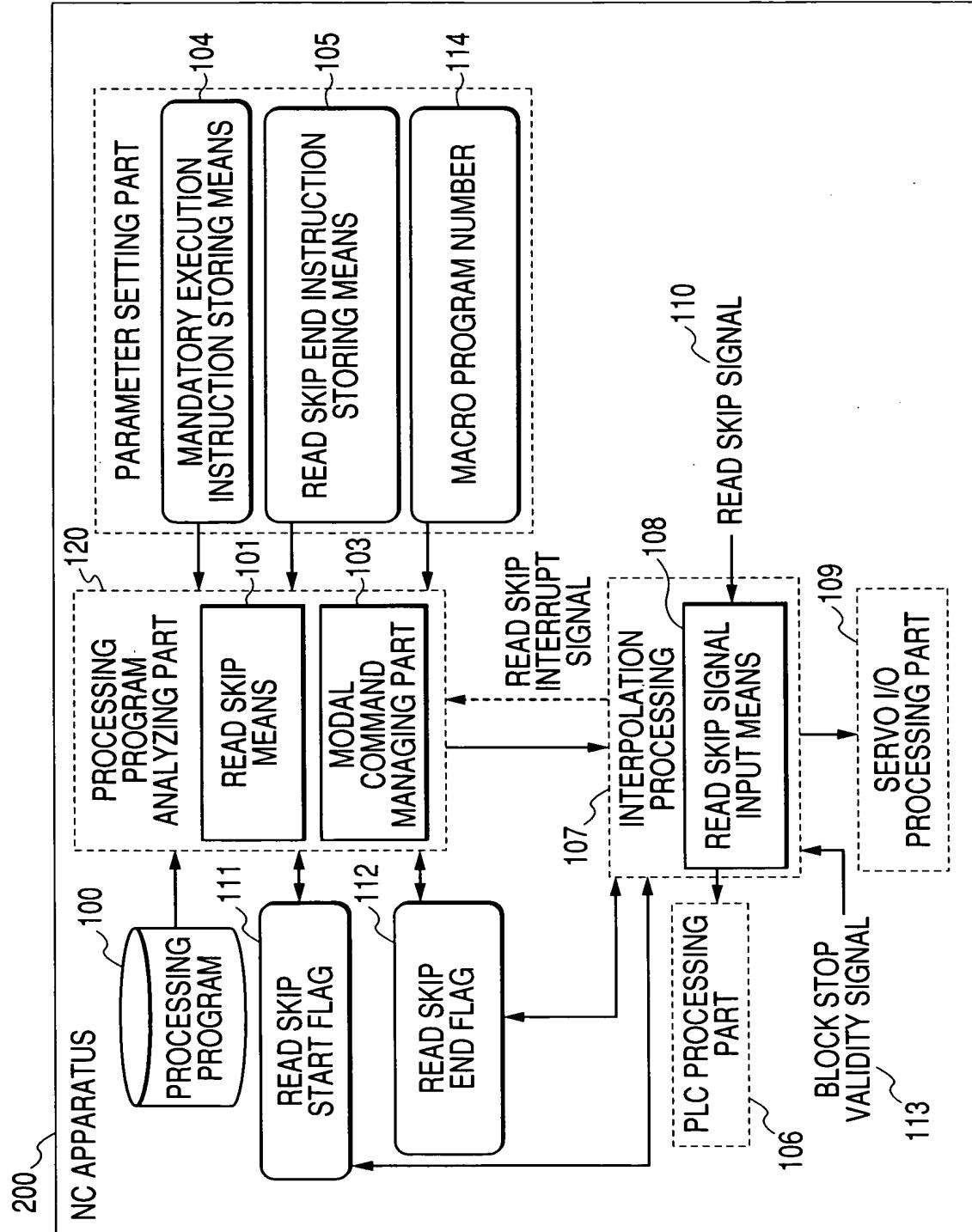


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FIG. 1

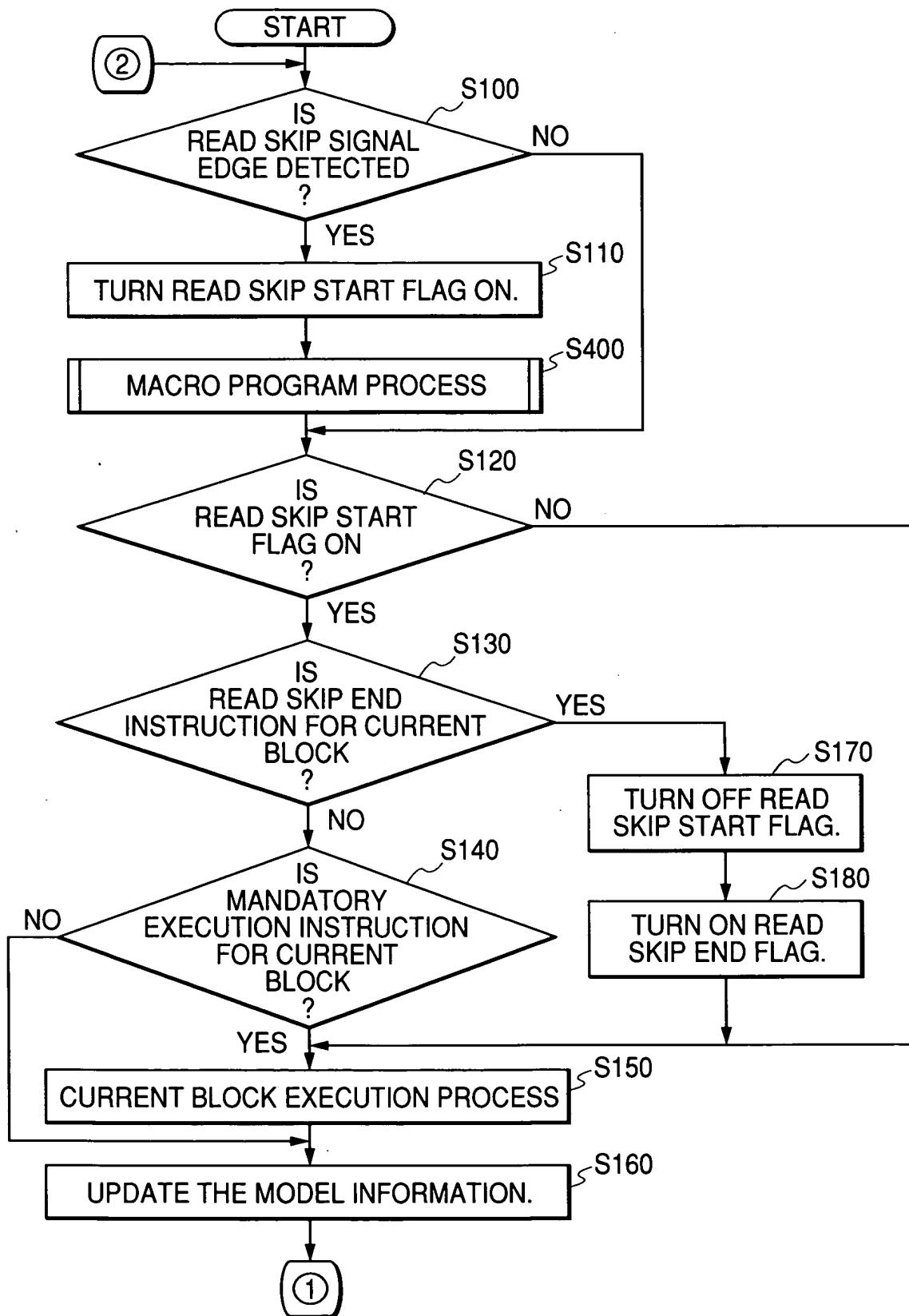


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FIG. 2

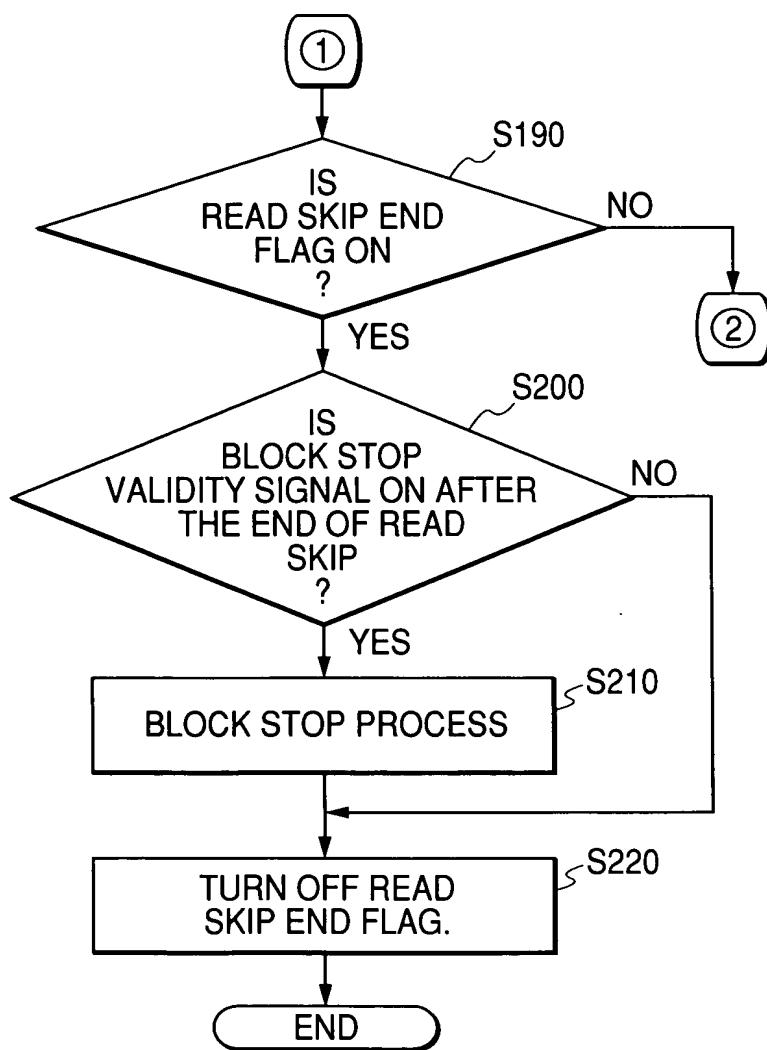


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FIG. 3

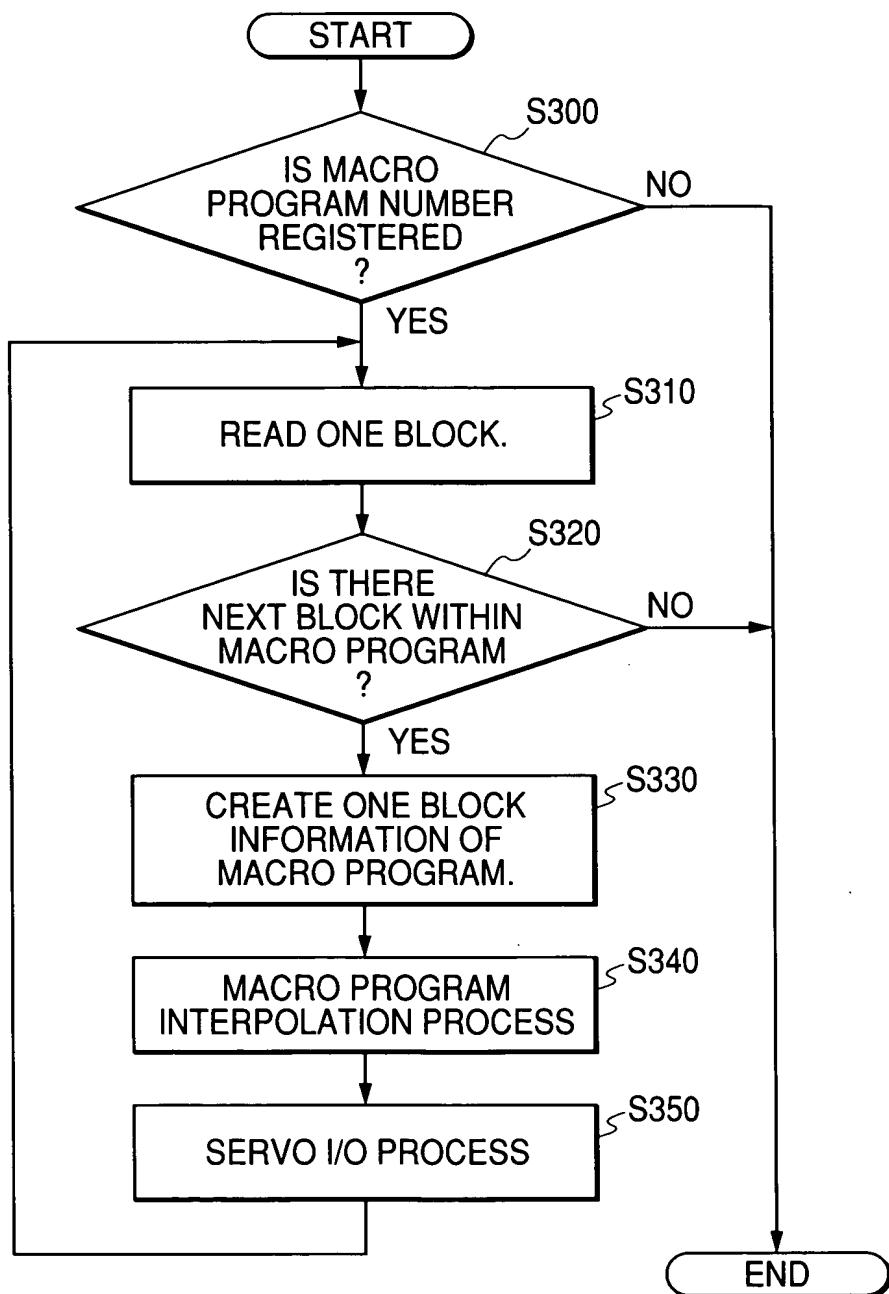


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FIG. 4



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FIG. 5

```
...
N010 T01 ;
N020 G91 G30 X0 Y0 Z0 ;
N030 M06 ;
N040 G90 X10. Y10.
N050 Z10. ;
N060 G01 Z50. F0.2;
...
N100 T02 ;
N110 G00 X50. Y50. ;
...
N300 G91 G30 X0 Y0 Z0 ;
N310 M06 ;
.....
...
```

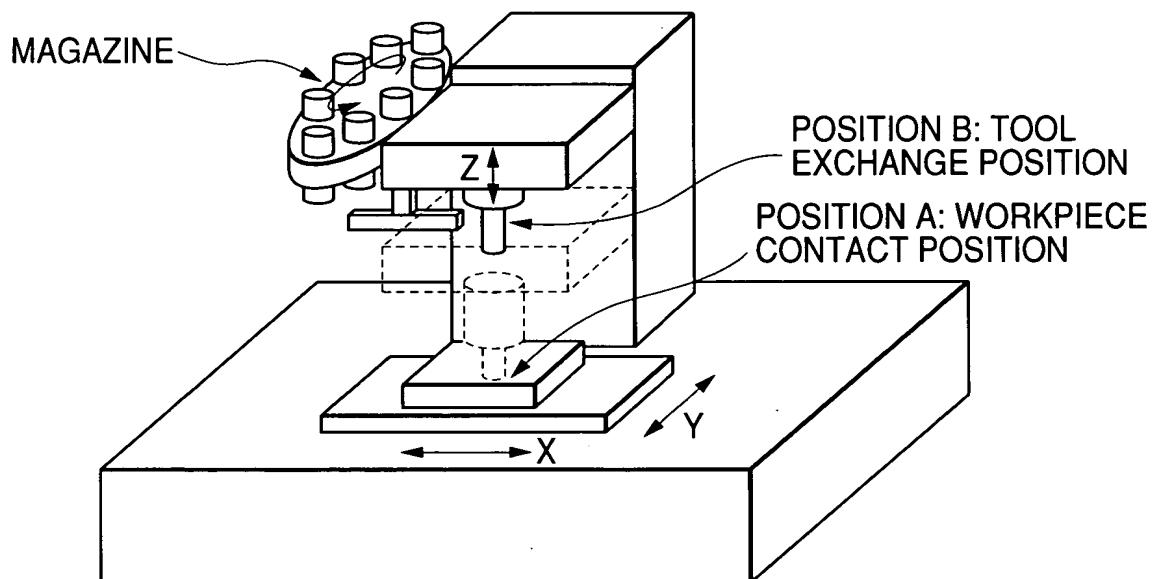
FIG. 6

```
G28 W0. ;
M99;
```

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FIG. 7



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FIG. 8

TOOL NUMBER	LONG SIZE	LONG WEAR	DIAMETER SIZE	DIAMETER WEAR	RESIDUAL DISTANCE	
					MACHINE POSITION	
1	1.120	0.000	1.020	0.000	X	0.910
2	2.020	0.000	1.900	0.000	Y	0.000
3	0.000	0.000	0.000	0.000	Z	1.000
4	4.002	0.020	3.055	0.100	B	0.000
5	0.000	0.000	0.000	0.000		
6	3.021	0.000	2.003	0.000		
7	0.000	0.000	0.000	0.000		
8	0.000	0.000	0.000	0.000		
9	0.000	0.000	0.000	0.000		
10	0.000	0.000	0.000	0.000		

G00Y15.B10;
G01X13.Z5.F2000;
...
...